

Work Order ID 85393

June 7, 2012 8:16:11 AM

85393

Page 1

Item ID: D3001-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 6/07/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/08/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: CLDate: 12/10/07

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3001	Rev B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3001								
<u>8532.046</u>	Dwg Rev: <u>3</u>								
	Prog Rev: <u>3</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B2-6-7B2-6-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

5 746 12-6-8

160

QC Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

5 12-6-8

170

Identify as per dwg & Stock Location: 178

0.00

170

Packaging

Memo

0.00

Packaging

5 12/6/8

Dart Aerospace Ltd

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/6/11 *[Signature]*
MF
12-06-08

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Picklist Print

June 7, 2012 8:16:11 AM

Page 1

Work Order ID: 85393

Parent Item: D3001-1

Parent Item Name: Doubler

Start Date: 6/07/12

Required Date: 6/08/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A01.03.22New IssueEC
IPP rev.B added scuffing NCR 061 EC
IPP Rev:C Now On Waterjet 07-12-13 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040 5052-H32 .040 Sheet		Purchased	No			100	sf	126.9000	0.7083	2.9823158			

B12-6-7

Location

Loc Qty

Loc Code

MAT022

126.9

117130

4.4

118641

64

119384

26

121192

32.5

119384

5

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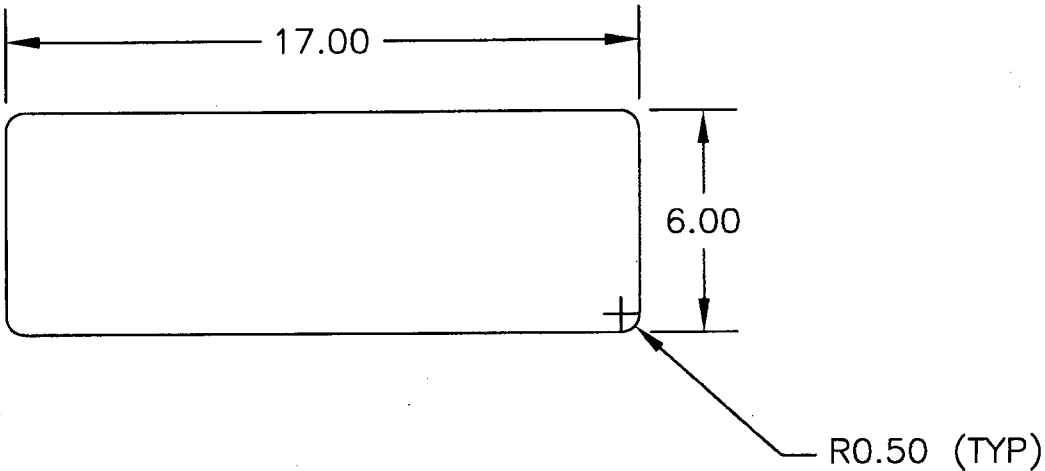
NOTE: Date & initial all entries

ART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3001	REV. B SHEET 1 OF 1
DATE 06.10.06	TITLE DOUBLER SCALE 1:5		
A	01.03.21	NEW ISSUE	
B	06.10.06	ADD BONDING PREP NOTE	

RELEAS NOTES
66-11-103 *7*

RELEAS NOTES
66-11-103 *7*



D3001-1 DOUBLER

CL12106107
W10: 85393

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32/H34 SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.040)
OR ALUMINUM 6061-T6 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) PREPARE FOR BONDING TO COMPOSITE STRUCTURE
PER DART QSI 006 4.10
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS TO 0.010 MAX



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